

Work Order ID 91656

91656

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October-11-12 10:32:43 AM

Item ID: D3136-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Window Assembly
 Start Date: 10/10/12 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 10/12/12 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Thermoform Thermoforming Machine	THERMOFORMING MACHINE Memo 1-Thermoform as per Dwg D3136 and Folio FTA002 Dwg Rev. <u>E</u> Folio Rev. <u>C</u> 2- Engrave Part # and Batch # , and affix labels (D3136-3)	0.00 0.00				x5			DAS 07 2-89 12/10/15
140 *140* Thermoform Thermoforming Machine	HAND FINISHING THERMOFORMING Memo Water sand and buff to remove scratches as required	0.00 0.00				x5			DAS 07 2-89 12/10/15
150 *150* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				x5			DAS 07 2-89 12/10/15

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Item ID: D3136-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Window Assembly

Start Date: 10/10/12 Start Qty: 10.00

10

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

Inspect edge and window deformation, wrap in plastic

180

Identify as per dwg & Stock Location: 7

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

DAS
16
12/10/15

(74)

41

Pto →
Last Page

12/10/15

ML5 12-10-15

W 12.10.15

Picklist Print

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Work Order ID: 91656

Parent Item: D3136-043

Parent Item Name: Window Assembly

Start Date: 10/10/12

Required Date: 10/12/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.02.04New issueKJ/DS
IPP Rev.B 07.05.29 Thermoform in-house DL
IPP rev C 07.09.28 Rev E dwg EC verified by:DD IPP Rev:D 10.06.24 added note in qc5
seq 170 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3108-9 Decal		Manufactured	No			100	Each	564.0000	2	20			
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Location	Loc Qty	Loc Code
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ST026	564	
34554	64	
46546	500	

MACRLICS.125 1/8" Polycast II Sheet		Purchased	No			170	sf	151.3490	3.9	39			
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Location	Loc Qty	Loc Code
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MAT019	151.349	
110633	3	
117324	0.2467	
117431	10.7967	
119591	15.16	
121850	122.1456	

DAS
07
10/10/15

22.22

18210-11

(12)

121850

216
D.V.

DART AEROSPACE LTD		Work Order:	
Description:		Part Number:	
Inspection Dwg:	Rev:		Page 1 of 1

[illegible]

Measured by:		Audited by:	DAS	Preliminary Approval:	
Date:		Date:	16 12/10/15	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

240
16
31

NCR: ☒ Yes ☐ No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: *AK*

Date: 12/10/17

QA Closed: *ck*

Date: 12/10/17

Work Order: <u>91456</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No. <u>D 3136-013</u>				Rework <input type="checkbox"/>		Skid-tube <input type="checkbox"/>		Crosstube <input type="checkbox"/>		Water Jet <input type="checkbox"/>		Engineering <input type="checkbox"/>	
NCR No. <u>129121</u>				Scrap <input checked="" type="checkbox"/>		Machining <input type="checkbox"/>		Small Fab <input type="checkbox"/>		Prod. Eng. Coord. <input type="checkbox"/>		Quality <input type="checkbox"/>	
				Use-as-is <input type="checkbox"/>		Thermoforming <input checked="" type="checkbox"/>		Finishing <input type="checkbox"/>		Rec/Store/Packaging <input type="checkbox"/>		Other <input type="checkbox"/>	
				Work Order Update <input type="checkbox"/>		Large Fab <input type="checkbox"/>		Composite <input type="checkbox"/>		Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup	<input checked="" type="checkbox"/>	12/10/15	160	When Removing window from Drap molding of thermoflexion operator causes a large Rupture on the Edge of the window.	<i>DAS 16 2-3</i> <i>AS7042 12/10/15</i>	→ Due to complaints + fit issues. Scrap + Destroy the part. (Best solution). Qty = 1		<i>DAS 16 2-3</i> 12/10/15	<i>DAS 16 2-3</i> AS7042 12/10/15
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear		General			
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced	
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure	
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld	
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled	
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved		
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong		
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input checked="" type="checkbox"/> Other	
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	needs better solution as removal parts off thermoflexion		
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration			
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence			
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions			

